

Need Tige 1st

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:21:08 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET
Job Number	32606		
Estimate Number	12840		
P.O. Number	N/A	Part Number	D35421
This Issue	5/25/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3542 REV A
First Issue	N/A	Project Number	N/A
Previous Run	32129	Drawing Revision	A
Written By	JLM 07.05.28		
Checked & Approved By			
Comment	Est Rev: A New Issue	07-04-23	JLM
	Est Rev: B updated powder coat per NCR	07.05.16	EC
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"	
			
Comment: Qty.: 0.3500 f(s)/Unit Total : 6.9993 f(s) 6061-T6 Bar 3" x 1.5" BATCH: M16530			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA684 Rev. AA & Dwg D3542 Rev. A			
	2-Deburr per dwg D3443		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING



POWDER COATING

m101601



Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*****ENSURE TO MASK INSIDE BORE*****

FZ

07/06/04 (20)

7.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(Q3K)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A 07/06/04

8.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

37243

4/2/05 (21)

9.0 QC21



FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

F07/06/05

Job Completion



U

8/06/05

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

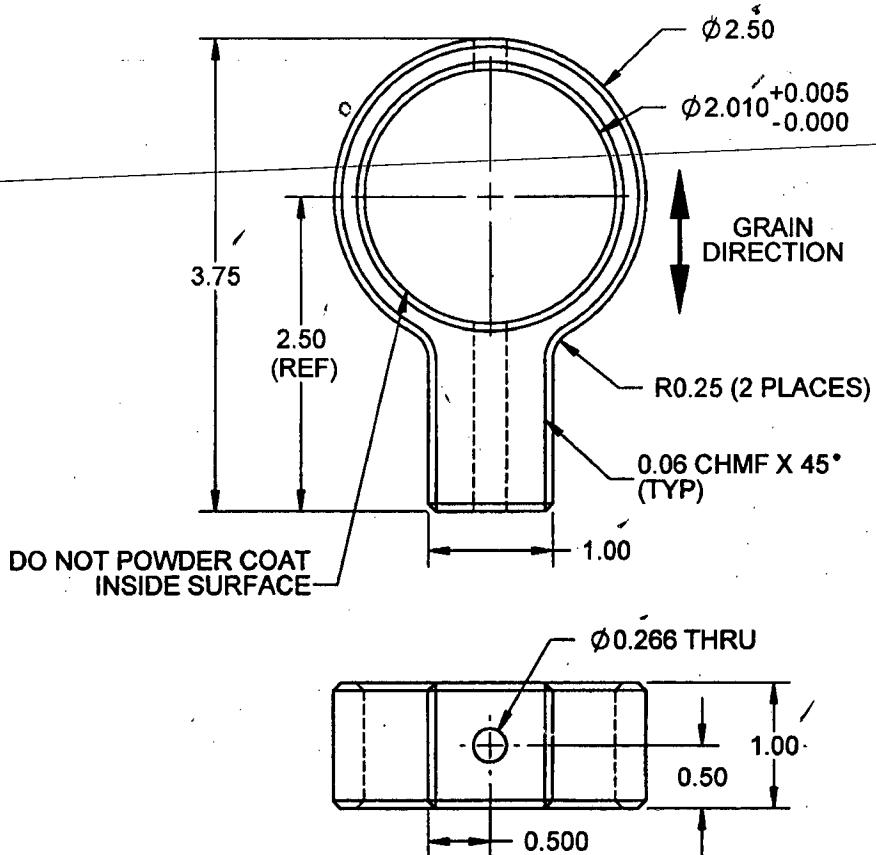
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



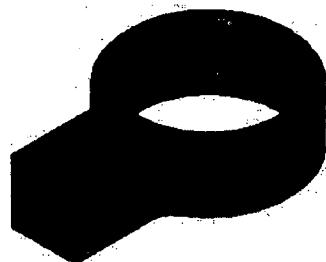
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3542
DATE 06.11.27		REV. A SHEET 1 OF 1
		TITLE SCALE BRACKET 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE

RELEASED
07.04.02 *H*



D3542-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *32606*



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	32606
Description: bracket	Part Number:	D 3542-1
Inspection Dwg: A3542 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L.	Audited by:	D.P.	Prototype Approval:	
Date:	07/05/31	Date:	07/05/31	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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